

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012327**Date Inspected:** 25-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Wuzhi Chang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Bay 11, Bolt Tension Test.

This QA inspector witnessed the lot testing of the A325M High Strength Bolts to determine the torque values for the minimum tension required. Below is a list of the lots tested and the average torque values determined. Also witnessed the testing for rotational capacity on same lot numbers.

1. Bolt Lot No: 7818Z, size M27 x 160, RC Set# DHGM270022, Nut Lot No: NC031Z, Washer Lot No: C1168Z and average torque value was 847 N-m.

2. Bolt Lot No: 6786Z, size M27 x 95, RC Set# DHGM270023, Nut Lot No: NC031Z, Washer Lot No: C1168Z and average torque value was 873 N-m.

SEGMENT: 6AE, 6BE&6CE (Panel Point 37-47)

This QA inspector performed visual testing and dimensional check on cope hole and welds access for OBG lift 6 East for smoothness. Some locations not comply with the ABF inspection report no: CWAHIR-6AE-02 dated 23rd

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Feb 2010. Those locations flush grinding and sharp edges removal required. All these details noted and forwarded to team leader for further action.

OBG TRIAL ASSEMBLY

This QA Inspector Randomly observed the following work in progress:

SEGMENT: 6BW

Shielded Metal Arc Welding (SMAW) welding of weld joint OBW6F-006. Welder is identified as 066413. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4b-FCM-1.

Shielded Metal Arc Welding (SMAW) welding of weld joint OBW6F-006. Welder is identified as 066413. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
